Quality Control

Work Order I Tuesday, April 12, 20								O		Page 1
Item ÍD: D32 Revision ID:	19-1		Accept				s	etup Sta		
Item Name: Plate Start Date: 4/12. Required Date: 4/18. Reference:	/2011 Start Qty: 40.00	t (MB) to Miles I		Cust Item I Customer:	D:			Sto	.	
Approvals: Pro	cess Plan:	Date: //-04/-	/2 Tooling:	Da	ıte:	-	R	tun Sta		
QC	:	Date:	SPC (Y/N):	Da	ite:			Ste	ob	
Sequence ID/ Work Center ID	Operation Description	300000000000000000000000000000000000000	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								***************************************	-
D3219	Rev A							_		
	FLOW WATER JET		0.00				B11-4	1 -51		
Waterjet	Memo		0.00					(= 3 \		
FLOW CNC Waterjet	I-Cut as p Dwg Rev: Prog Rev:								(DE	3
1 10 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	QC2- Inspect parts off	f machine FAI/FAIB	0.00						i	
QC Quality Control	Memo	ŧ	0.00				Bun	16->1		
	QC8- Inspect parts - s	econd check	0.00 کررامد	171			(autc	>		
QC.	Memo		0.00	,		(-400			

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROC	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval . QC Inspector.	
				· 					r.		
									•		
Part No		PAR #:	Fault Cate	gory:	NCR	: Yes N	lo DQ A	\:	_ Date: _		
			_ Dispositio	n:	QA:	QA: N/C Closed: Date:					
NCR:		W	ORK ORD	ER NON-CONFOR	MANCE	(NCR)					
DATE	STEP	Description of NC		Corrective Action Section B			Verific		Approval	Approval	
DAIL	OIL.	Section A	Initial Chief Eng	Action Description Chief Eng	on ·	Sign & Date	Section C		Chief Eng	QC Inspector	
								,			

Work Order ID 68338

Tuesday, April 12, 2011 10:02:36 AM

Item ID:

D3219-1

Revision ID:

Item Name: Plate

Start Date: Required Date: 4/18/2011

4/12/2011

Start Qty: 40.00

Req'd Qty: 40.00

Accept



Setup Start

Stop



Page 2

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Reject

Stop

Sequence ID/ **Work Center ID**

130

Small Fab

Small Fab

Operation Description

Small Fab

Memo

Memo

Memo

1-Deburr if necessary.

Set Up/ **Run Hours**

0.00

Tool ID

Cust Item ID:

Customer:

Tool # Plan

Code

Qty

Accept Qty

Reject

Insp. Number Stamp

0.00

140

Quality Control

QC5- Inspect part completeness to step on W/O

150

Packaging

Packaging

Identify as per dwg & Stock Location:

*** STOCK IN STEP CELL***

0.00

0.00

In.04.27

	-													
W/O:			WORK ORDER CHANGES											
DATE	STEP		PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
				2										
Part No	:		PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQ	A:	_ Date: _				
Resolution:				Disposit	ion:	QA: N/C Closed:								
NCR:				WORK OR	DER NON-CONFO	DRMANCE	(NCR)						
DATE	STEP	Des	Description of NC		Corrective Action Section				Verification	Approval	Approval			
DAIL	Se		Section A	Initial Chief Eng	Action Descri	ption	Sign & Date		tion C	Chief Eng	QC Inspector			
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Work Order ID 68338

Tuesday, April 12, 2011 10:02:36 AM



Page 3

Item ID:

D3219-1

Accept



Setup Start

Stop

Stop



Revision ID:

Item Name:

Plate

4/12/2011 **Start Date:**

Start Qty: 40.00

Required Date: 4/18/2011 Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

	_	
Δ	nnrovals	٠

Process Plan:

Date:_____

Tooling:

Date:

Run Start

QC:

Operation

Date:

SPC (Y/N):

Date:

Sequence ID/

Work Center ID

160

Description QC21- Final Inspection - Work Order Release Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp.

QC Quality Control

Memo

0.00

Number Stamp

mx 11-04-27

	-									
W/O:		·	W	ORK ORDER CHANG	iES					
DATE	STEP	PRO	OCEDURE CH	ANGE	I	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cat	egory:	_ NCR:	Yes N	lo DQ	A:	Date: _	
Resolution:			Dispositi	on:	QA: N	QA: N/C Closed: Date: _				
NCR:			WORK OR	DER NON-CONFORM	ANCE (NCR)	ı			
DATE	STEP	Description of NC		tion B		cation	Approval	Approval		
	SIEP Section A	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector

Picklist Print

Tuesday, April 12, 2011 10:02:42 AM

Work Order ID: 68338

D3219-1

Parent Item Name: Plate



Start Date: 4/12/2011

Required Date: 4/18/2011

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:

Parent Item:

IPP A□04.04.19□New issue□KJ/JLM□

ESR B 06.05.25 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	132.9000	0.0964	4.058947	1125	61	
										14	3/1-4-2	1	

6061-T6 .125 Sheet

Location	Loc Qty	Loc Code
MAT021	132.9	
113608	108.9	
116700	24	



	•							•
W/O:			W	ORK ORDER CHANG	ES			,
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	lo DQA:	Date: _	
	R	esolution:	Dispositi	on:	sed:	Date: _		
NCR:		V	VORK ORI	DER NON-CONFORMA	ANCE (NCR)	ı		
DATE	STEP	Description of NC		ion B	Verification	Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
				•				
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DART AEROSPACE LTD	Work Order:	48338
Description: Plate	Part Number:	D3219-1
Inspection Dwg: D3219 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.316	+0.005/-0.000	316	> -		U YROZ	
2.293	+/-0.005	2.290	7		V	
2.965	+/-0.010	2964	8		V	
0.566	+/-0.010	,565	>		V	
0.375	+/-0.010	-378	×		V	
R0.125	+/-0.010	125	ملا		R.G.	
13.9°	+/-0.5°	13.90	7			
					·	

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 11-4-	Date: 1/04	Date:	N/A

Rev	Date	Change	1	Revised by	Approved
Α	04.04.19	New Issue	,	KJ/JLM	
В	07.09.06	13.9° dimension added	1 ;	KJ/JLM , ,	
С	08.04.15	0.125 dimension removed	1	KJ/DD ox	N/

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No:											
		esolution:	Disposition: Q			QA: N/C Closed:			Date:		
NCR:				ER NON-CONFOR							
DATE	STEP	Description of NC	Corrective Action Section B			Verification			Approval	Approval	
DAIL		Section A	Initial Chief Eng	Action Description Chief Eng	on 	Sign & Date	Section C		Chief Eng	QC Inspector	
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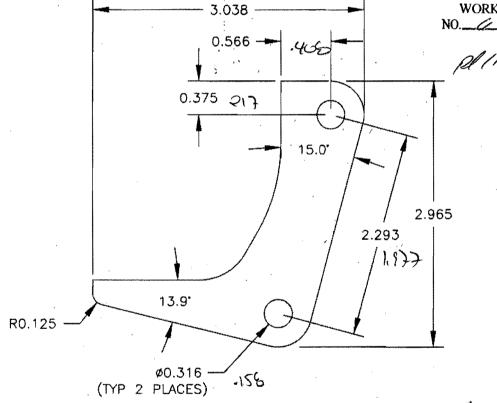




	DESIGN (A)	DRAWN BY		OSPACE LTD ONTARIO, CANADA
ľ	CHECKED,	APPROVED,	DRAWING NO.	REV. A
1	«:- #	- A-	D3219	SHEET 1 OF 1
İ	DATE		TITLE	SCALE
	03.10.10		PLATE	1:1
T	Α	03.10.10	NEW ISSUE	

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE **WORK QRDER** NO_U8338



D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11) (REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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•		PAR #:	Fault Category: NC			R: Yes I	No DQ	A :	Date:		
		esolution:	Disposition: Q			QA: N/C Closed: Date:					
NCR:		•	WORK OR	DER NON-CONFOR	RMANCE	(NCR)				
DATE	STEP	Description of NC		Corrective Action Section B			Verification			Approval	
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